

Date: Wednesday, 6/28/2006 10:14:38 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPLATE
 Job Number : 27716
 Estimate Number : 12467
 P.O. Number : N/A
 This Issue : 6/28/2006 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : SMALL /MED FAB
 Previous Run : N/A
 Written By : SAE COMMENT BELOW
 Checked & Approved By : 06-06-28
 Comment : Est Rev A New Issue 06-06-20 JLM

Part Number : D3512 9H 06.05.28
 Drawing Number : D3512 PREL
 Project Number : N/A
 Drawing Revision : PREL
 Material : N/A
 Due Date : 7/5/2006 Qty: 4 Um: Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

M1010S200A

16 GA.

1010/1025/A21/6aA SHEET



Comment: Qty.: 0.2741 sf(s)/Unit Total : 1.0962 sf(s)

1010/1025/A21/6aA SHEET

(M1010S200A)

Batch: 1100403

M42 9/31

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3512

Dwg Rev: PrelProg Rev: Prel

2-Deburr if necessary

SD 06:06:29

4

3.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Deburr if necessary

Form as per dwg D3512 using DT8179

5. SD 06/07/04 4

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-07-04 4

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using DT8210 as per Dwg D3512 & QSI 004

Qty Description Batch M100780

H.M 06-07-05

4

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
06-07-19	1.0	3 parts SCRAP, DUE MATERIAL DAMAGE 6 parts SCRAP, WRONG MATERIAL, (EST. WAS WRONG) update estimate.	JM	-	-	PH 06-07-19	06-07-19	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-07-19	1.0	3 parts scrap, due to material damage: 6 parts scrap due to wrong material. R-L. Estimate was wrong wrong material.	JB 06-07-19	redo estimate for the proper mat'l. Scrap: destroy wear plates.	JM 06-07-20	06-07-20	PH 06-07-19	06-07-19

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 06/07/24

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Wednesday, 6/28/2006 10:14:38 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 27716

Part Number: D3512

Job Number:



Seq. #:

Machine Or Operation:

Description :

A/R 7560 Hardcoat Rod M100780

H.M 06-07-05

6.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

06/07/05

(4)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

am 06-07-18

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

06 07 18

(4)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 85363

AR 06/07/19

(4)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Doc 06/07/19

(4)

Job Completion



U 06-07-19

Return to Alt
after completion
At 06-07-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

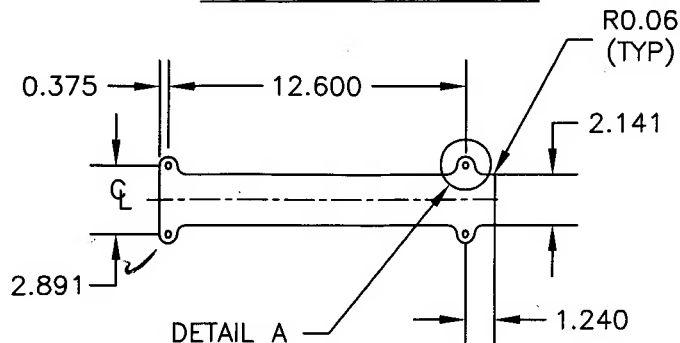
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

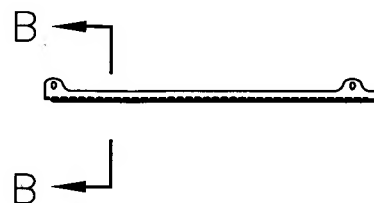
PRELIMINARY ISSUE

DESIGN <i>AH</i>	DRAWN BY <i>AH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO. D3512	REV. A SHEET 1 OF 1
DATE 06.04.21		TITLE WEARPLATE	SCALE 1:8
A	06.04.21	NEW ISSUE	

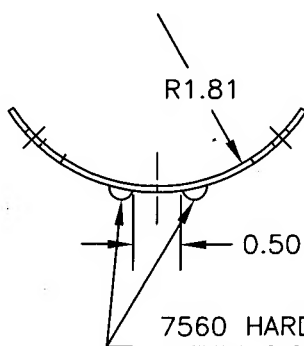
D3512-1F FLAT PATTERN



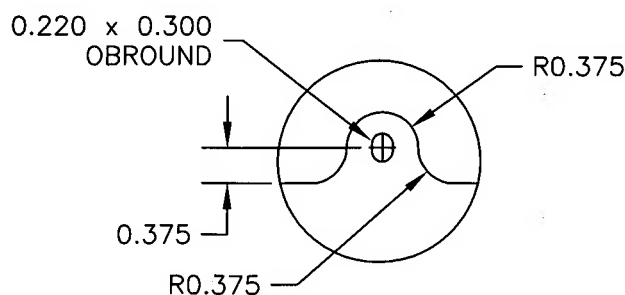
D3512-1 BENDING DETAIL



SECTION B-B SCALE 2:5



DETAIL A SCALE 2:5



D3512-1 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, SHOP COPY 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.063 THICK) (REF. DART MATERIAL SPEC M1010-S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS IN INCHES
- 5) WELD PER DART QSI 004
- 6) PART IS SYMMETRICAL ABOUT CENTERLINE
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.015

RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27716

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2017 JAN 11 14:11

m 9131

产品质量证明书

INSPECTION CERTIFICATE

宝山钢铁股份有限公司
BAOSHAN IRON & STEEL CORPORATION LTD.

上海市宝山区同济路1800号 邮编 201100
1800 TONGJI ROAD, BAOSHAN DISTRICT
201900 SHANGHAI P. R. CHINA
TEL (021) 56648000 - 226
FAX (021) 56601754

单位名称 YONER	宝钢集团国际经济贸易总公司	产品名称 PRODUCT	COLD ROLLED STEEL SHEET IN COIL		
单位 WASER	宝钢集团国际经济贸易总公司	代号 CUSTOMER'S NO.	004155	证书号 CERTIFICATE NO.	100619109351
堆 放 位 置 LOCATION	ASTM A366 CQ PT. A - PW. A <i>per Day</i> <i>01.09.27</i>	客户订单编号 CUSTOMER ORDER NO.			
		签发日期 DATE OF ISSUE	2000/05/25	交货日期 DATE OF DELIVERY	2000/06/11
		许可证号 LICENSE NO.		合同号 CONTRACT NO.	LA30038001

捆包号 PACK NO	件数 QTY	炉号 HEAT NO	规格及重量 MATERIAL DESCRIPTION					化学成分 CHEMICAL COMPOSITION % (熔体分析 HEAT ANALYSIS)													拉伸试验 TENSILE TEST G. 1 - L 2				弯曲 BEND TEST	硬度 HARDNESS	冲击 IMP	其他 OTHER		
			厚度 THICK	宽度 WIDTH	长度 LENGTH	张数 SHEETS	重量 MASS (kg)	C	Si	Mn	P	S								屈服 Y.S.	抗拉 T.S.	伸长 EL								
3	02	1	123359				12940	4		24	19	11								255	350	41				53				
3	03	1	123359				13950	4		24	19	11								255	350	41				53				
4	02	1	123360				13600	5		24	13	9								310	350	40				53				
4	03	1	123360				12310	5		23	13	9								310	350	40				53				
5	02	1	123356				12960	4		23	14	11								250	345	39				50				
1	03	1	123756				12870	3		23	22	13								245	350	42				51				
2	02	1	123428				13920	4		23	13	14								275	345	41				54				
2	03	1	123828				13910	4		23	13	14								275	345	41				54				
3	02	1	123827				13140	5		24	15	16								255	355	42				53				
1	03	1	123827				13260	5		24	15	14								295	355	39				55				
Total			转下页		转下页		SIZE: 0.9560 "MIN X 48.375" X																							

注 明 事 项 REMARKS	
解 释 TES	Y S = YIELD STRENGTH T. S. = TENSILE STRENGTH LL = ELONGATION G. L. = GAUGE LENGTH 11 = 5.65SBRT (Φ D) 12 = 50MM 13 = 80MM 401: HRB 402: HRF 403: HR30T 404: HV 405: BR15T 406: ER10BEN
备 注 FOR TD	本产品已按上述要求进行制造和检验, 其结果符合要求, 特此证明。 WE HEREBY CERTIFY THAT MATERIAL DESCRIBED HEREIN HAS MANUFACTURED AND TESTED WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE MATERIAL SPECIFICATION.
	技术部部长 DIRECTOR OF TECHNICAL DE

DKS - ASTM A366 1018-1020
Received ASTM #366 - ACCEPTABLE

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